

Work Order ID 73423

Wednesday, August 31, 2011 3:16:58 PM



Page 1

Item ID: D3794-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Gasket

Start Date: 8/31/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 9/16/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: CL Date: 11/09/01 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3794	Rev A								

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3794 ☐ Dwg Rev: A ☐ Prog Rev: A ☐ 2-
Deburr if necessary

B11-9-28

(17)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-9-28

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

S. W. 29

(17)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73423

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Page 2

Item ID: D3794-3

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Item Name: Gasket

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Required Date: 9/16/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: *FP-2*

0.00



Packaging

Memo

0.00

Packaging

17- BR 11-9-29

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

n/10/3 JF
ME 11-09-29

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, August 31, 2011 3:16:55 PM

Page 1

Work Order ID: 73423



Parent Item: D3794-3



Parent Item Name: Gasket



Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 08-05-13 new issue DD verified by:EC
IPP Rev:B 08-05-23 revA as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063 		Purchased		No		100	sf	583.5500	1.2828	17.104	22-		
NEOPRENE SHEET 0.063											 B11-9-28		

Location

Loc Qty

Loc Code

MAT052

583.55

117295

55.68

118026

127.87

118663

400

118663

(17)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	73423
Description: Gasket		Part Number:	D3794-3
Inspection Dwg: D3794	Rev: A	Page 1 of 1	

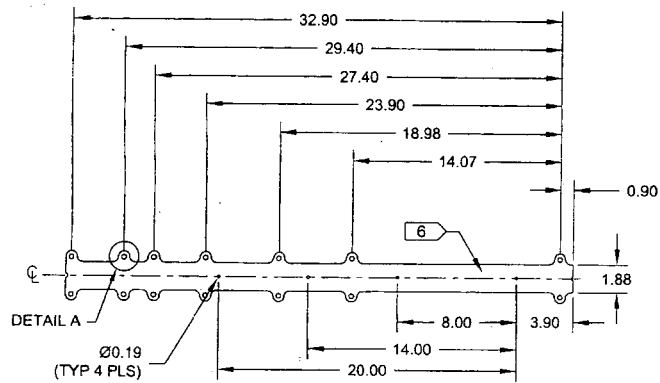
FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

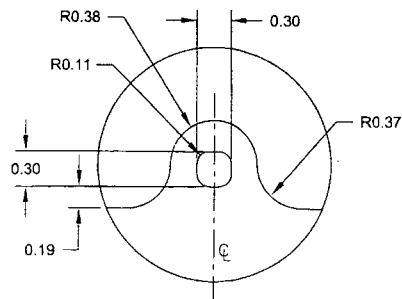
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.19	+0.005/-0.001	.190	x		V HB02	
0.300 x 0.300	+/-0.010	306x306	x		V	
1.88	+/-0.030	1.888	2		V	
4.281	+/-0.010	4.290	x		V	
6.44	+/-0.030	6.422	2		V	
6.00	+/-0.030	6.005	2		T HB01	
6.75	+/-0.030	6.75	x		T	
2.00	+/-0.030	2.000	x		T	
4.75	+/-0.030	4.75	0		T	
9.50	+/-0.030	9.50	2		T	
14.25	+/-0.030	14.25	2		T	
17.75	+/-0.030	17.75	2		T	
26.74	+/-0.030	26.74	2		T	
29.23	+/-0.030	29.23	x		T	

Measured by: B	Audited by: S	Prototype Approval:	N/A
Date: 11-9-28	Date: 11/2/29	Date:	N/A

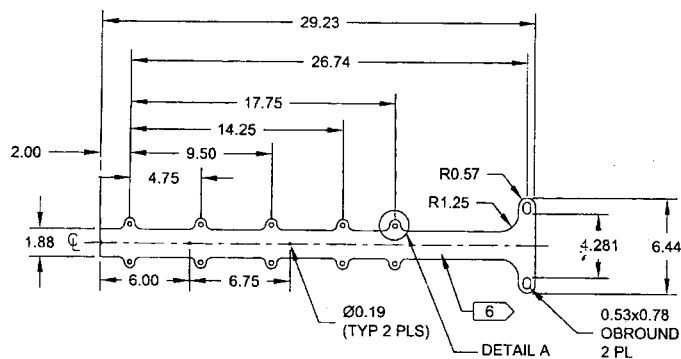
Rev	Date	Change	Revised by	Approved
A	08.05.28	New Issue	KJ/DD	
B	08.10.17	17.75 revised per Dwg Rev. A	KJ/DD	



D3794-1 GASKET



DETAIL A
SCALE 8X



D3794-3 GASKET

NOTES:

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "DXXXX-X" USING WHITE FINE POINT PERMANENT INK MARKER OR LABEL
- 7) WEIGHT: D3794-1 - 0.23 LBS, D3794-3 - 0.22 LBS

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 73423

CDL1109/01

RELEASED
08-05-13 MW

A NEW ISSUE		PH	08.05.14
REV.	DESCRIPTION	BY	DATE
DESIGN	PH		
DRAWN	PH		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.05.14		

DART AEROSPACE USA, INC	
PORT HADLOCK, WA	
DRAWING NO.	REV. A
D3794	SHEET 1 OF 1
TITLE	SCALE
GASKET	NTS

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